

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	BRACKET
Job Number	36546	Part Number	D32072
Estimate Number	11142	Drawing Number	D3207 REV A
P.O. Number	N/A	Project Number	N/A
This Issue	1/2/2008	Drawing Revision	A
Prsht Rev.	NC	Material	N/A
First Issue	N/A	Due Date	1/9/2008
Previous Run	N/A	Qty:	10
Written By		Um:	Each
Checked & Approved By	08-01-02		
Comment	Est A 04.04.15 New issue KJ/RF		

Additional Product

Job Number:			
Seq. #:	Machine Or Operation:	Description:	
1.0	M2024T3S050	2024-T3 .050 sheet	
			
<p>Comment: Qty.: 0.1502 sf(s)/Unit Total : 1.5015 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.050" thick (M2024T3S.050) Identify for D3207-2 103210 Batch: 103210 B 08-1-2</p>			
2.0	SHEAR	SHEAR	
			
<p>Comment: SHEAR (1) Flat pattern makes either D3207-2 Cut blank: 6.5100" x 2.880" (+0.020/-0.000) grain along 2.880"</p>			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
<p>Comment: HAAS CNC VERTICAL MACHINING #1 WATER SET Machine as per Folio FA341 and Dwg D3207 Deburr Stack of 10</p>			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</p>			

Date: Wednesday, 1/2/2008 11:43:19 AM
User: David Duval

Process Sheet

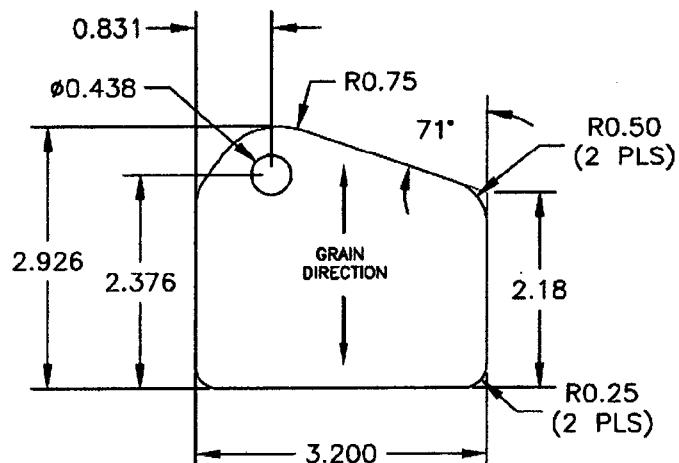
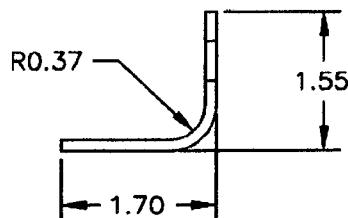
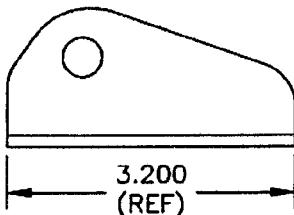
Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: BRACKET
Job Number: 36546		Part Number: D32072
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK 
Comment: SECOND CHECK  <i>08/01/08 (10)</i>		
6.0	BRAKE NC	NC BRAKE 
Comment: NC BRAKE Form 1/2 of stack for D3207-2 as per Dwg D3207 Identify as D3207-2  <i>SB 08-01/03</i> <i>(10)</i>		
7.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP  <i>08/01/03 (10)</i>		
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1  <i>(10)</i> <i>BK 08-01-03</i>		
9.0	POWDER COATING	POWDER COATING 
Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3  <i>(10)</i> <i>m 105642</i> <i>(10)</i> <i>BK 08-01-08</i>		
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT CHEMICAL CONVERSION COAT  <i>(10)</i> <i>M 08/01/08</i>		
11.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>ST 243A</i>  <i>(10)</i> <i>AS 08/01/08</i>		
12.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE  <i>(10)</i> <i>D 08/01/09</i>		
Job Completion 		<i>W 08/01/09</i>

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE	04.01.27	TITLE	SCALE

SHEET 3 OF 3

1:2

RELEASED
04.04.05**D3207-5 FLAT PATTERN****D3207-5 BEND DETAIL****D3207-5 BRACKET**

- 1) BREAK ALL UNMARKED SHARP EDGES CORNER 0.005 TO 0.010
- 2) MATERIAL: 6061-T6 (QQ-A-250/11) 0.125" THICK (M6061T6S.125)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

SART AEROSPACE LTD	Work Order:	36546
Description: BRACKET	Part Number:	D3207-2
Inspection Dwg: D3207-2 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

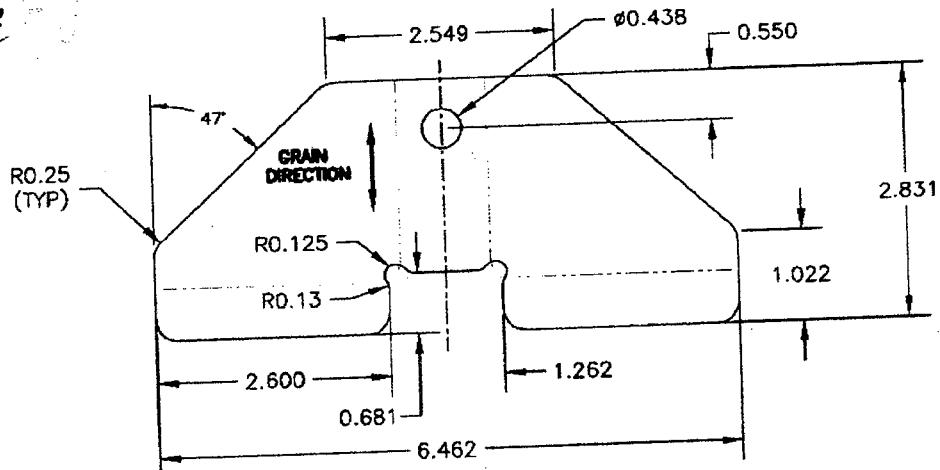
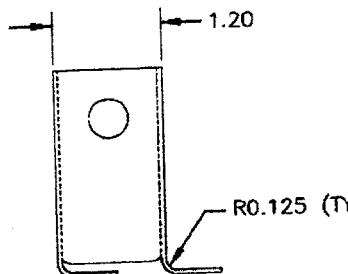
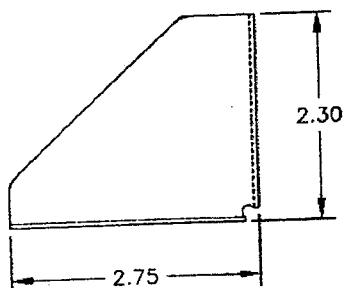
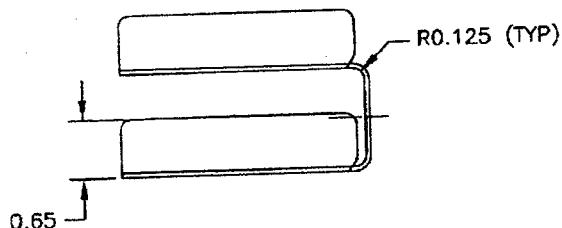
X First Article Prototype

Measured by: VB	Audited by: S	Prototype Approval: A
Date: 08-1-2	Date: 08/01/03	Date: 08/01/03

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3207	SHEET 1 OF 3
DATE		TITLE	SCALE
04.01.27		BRACKET	1:2
A	04.01.27	NEW ISSUE	

REF ID: A40413
04.01.27D3207-1/-2 FLAT PATTERND3207-1 BEND DETAIL (SHOWN)
D3207-2 OPPOSITED3207-1/-2 BRACKET

- 1) MATERIAL: 2024-T3 (00-A-250/4) 0.050 THICK (M2024T3S.050)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

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